

Date: Friday, 25/04/2008 12:49:02 PM
User: Jean-Luc Menard

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	: PLATE		
Job Number	: 38801					
Estimate Number	: 13269					
P.O. Number	:		Part Number	: D323851		
This Issue	: 25/04/2008	S.O. No. :	Drawing Number	: D3238 REV.D U/R		
Prsht Rev.	: NC		Project Number	: N/A		
First Issue	: / /	Type : SMALL /MED FAB	Drawing Revision	: D U/R		
Previous Run	:		Material	:		
Written By	:	<i>JL 08-04-25</i>	Due Date	: 02/05/2008	Qty:	2 Um: Each
Checked & Approved By	:					
Comment	: Est Rev:A New Issue 08-04-18 DD verified by:EC					

Additional Product

FOR ENGINEERING USE ONLY

PROTOTYPE

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M6061T6B0250X06000	6061-T6 Bar .25" x 6.0"
 Comment: Qty.: 0.0292 f(s)/Unit Total : 0.0584 f(s) 6061T6 aluminum bar 0.250" X 6.00" batch: <u>107130</u> HB 8-4-28		
2.0	WATER JET	FLOW WATER JET
 Comment: FLOW WATER JET 1-Cut as per Dwg D3238 Dwg Rev: <u>D</u> HB 8-4-28 Prog Rev: <u>D</u>		
2-Deburr if necessary		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
 HB 8-4-28		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
 SF 08/04/29 (3)		
Comment: SECOND CHECK		
5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
 SF 08/04/29 (3)		
Comment: 1- Face mill as per dwg D3238 2-Deburr as per dwg D3238		
20 08/04/29 (3)		

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 38801

Part Number: D323851

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



C 08/04/29 (X5)

Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

F 08-04-29 (3)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ENGINEERING

APPROVAL AS 08/04/29



(3)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Very

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/08/29

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



Change w/o 08/08/29

08/08/29

DART AEROSPACE LTD	Work Order:	38801
Description: PLATE	Part Number:	03238-51
Inspection Dwg: 3238-51 Rev: 1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

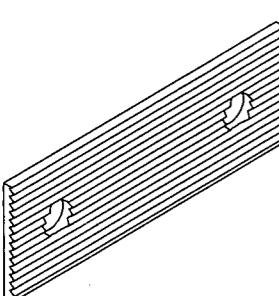
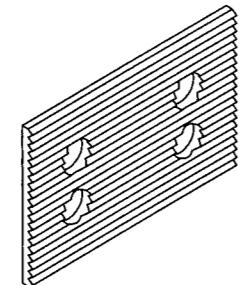
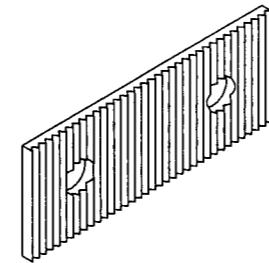
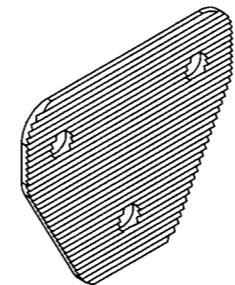
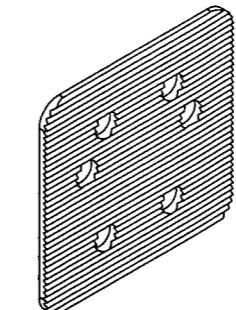
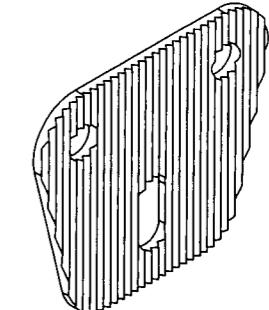
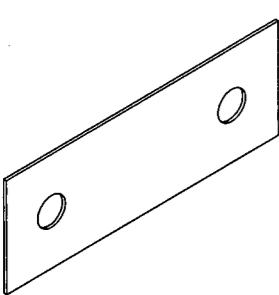
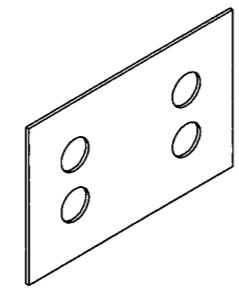
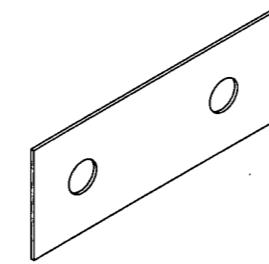
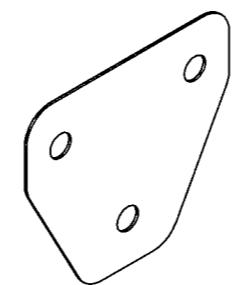
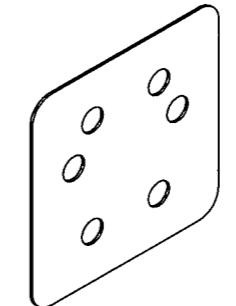
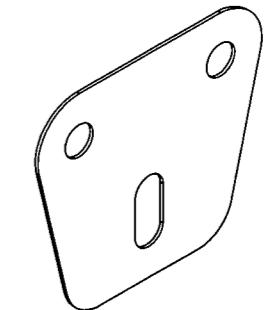
First Article Prototype

Measured by: AB /24
Date: 8-4-29

Audited by:	85 ✓ Dooly
Date:	08/04/29

Prototype Approval:	<i>AS</i>
Date:	08/04/29

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

D3238-1 PLATED3238-3 PLATED3238-5 PLATED3238-21 PLATED3238-23 PLATED3238-25 PLATED3238-11 PLATED3238-13 PLATED3238-15 PLATED3238-31 PLATED3238-33 PLATED3238-35 PLATE

D3238-41/-51/-61 PLATE (SIMILAR)

NOTES:

1) MATERIAL: -1/-3/-5/-21/-23/-25 PLATE:
2024-T3 ALUMINUM SHEET
PER QQ-A-250/4 OR AMS 4037
REF. DART SPEC M2024T3S

-11/-13/-15/-31/-33/-35 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.020 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC M6061T6S.020

OR: 5032-H32 ALUMINUM SHEET, 0.020 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.020

-41 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF. DART SPEC M6061T6S.040

OR: 5032-H32 ALUMINUM SHEET, 0.020 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
REF. DART SPEC M5052H32S.040

-45/-51/-55/-61 PLATE:
6061-T6 (OR 6061-T62) ALUMINUM SHEET
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF DART SPEC M6061T6S.250)
OR: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF DART SPEC M6061T6B)

NOTES (CONTINUED):

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) NOTE DELETED |

7) NOTE DELETED |

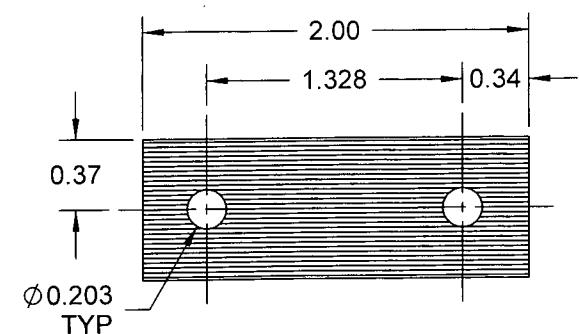
8) IDENTIFICATION: IDENTIFY WITH DART P/N "D3238-X" USING FINE POINT PERMANENT INK MARKER

9) WEIGHT: 0.01 lbs APPROX

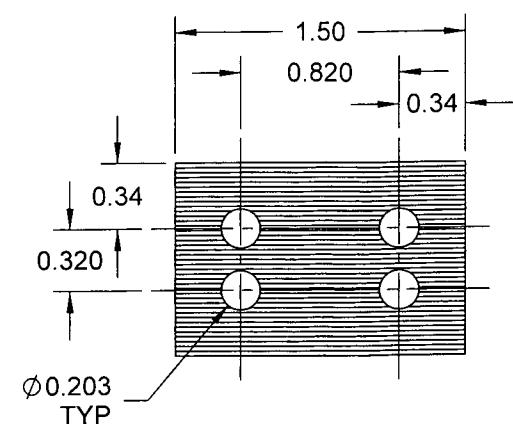
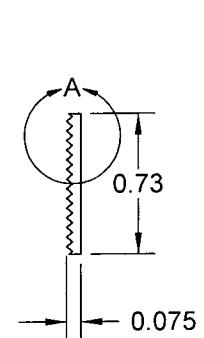
PROTOTYPE
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D	REDRAW TO SOLIDWORKS FORMAT. ADD -41/-45/-51/-55 & -61. DELETE NOTES 6 & 7.	AJS	08.04.02
C	ADD 5052-H32 OPTION	CB	07.02.19
B	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	CB	07.01.17
A	NEW ISSUE	CP	03.11.25
REV.	DESCRIPTION		
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	
MFG. APPR.		REV. D	
APPROVED		D3238	
DE APPR.		SHEET 1 OF 4	
DATE	08.04.02	TITLE	
		PLATE	
		SCALE	
		NTS	
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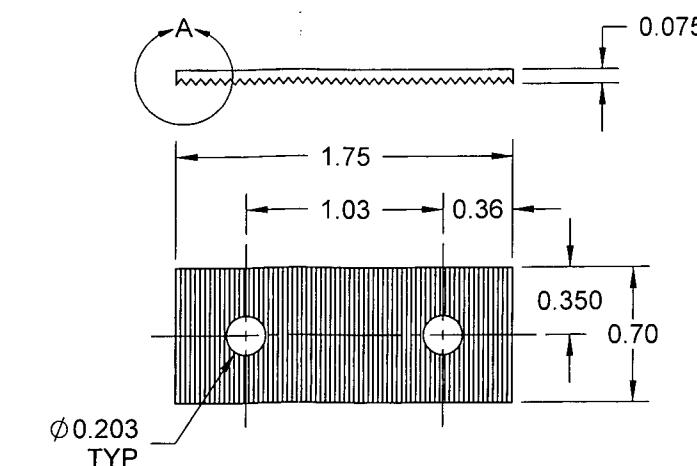
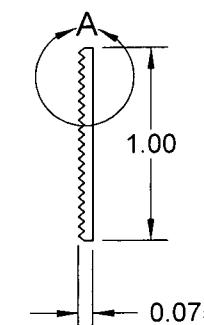
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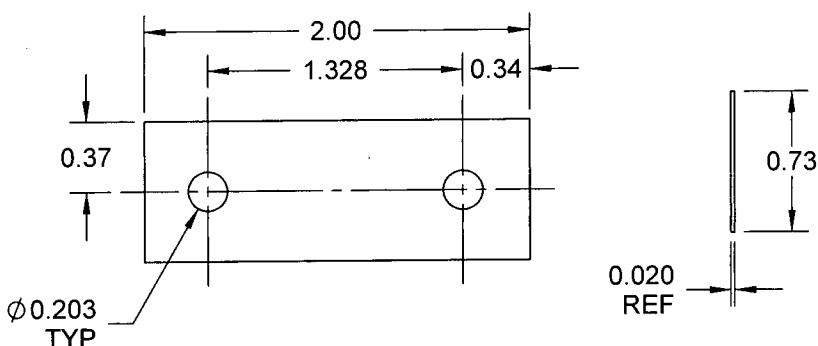
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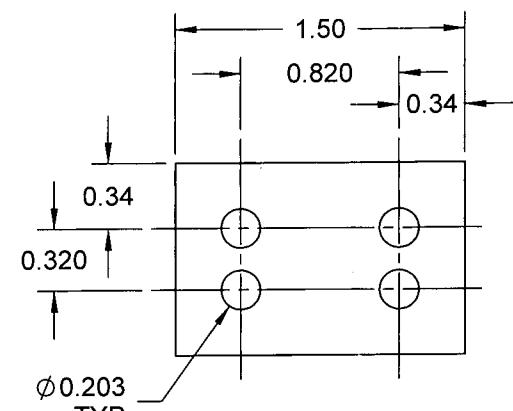
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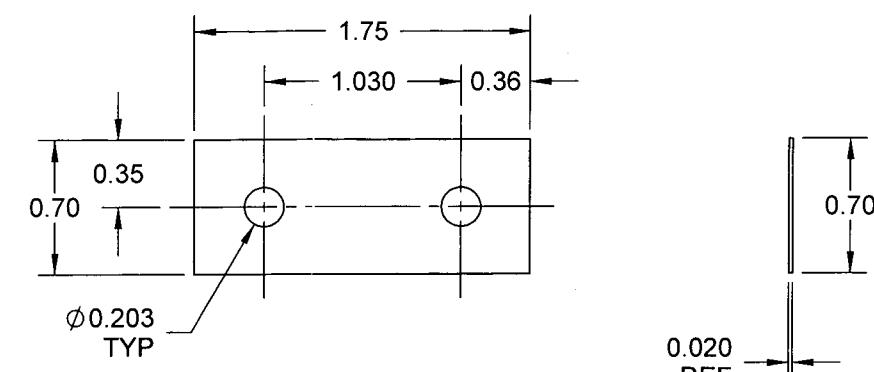
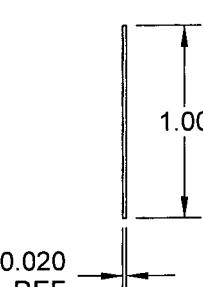
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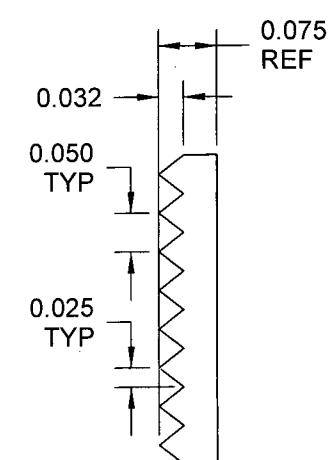
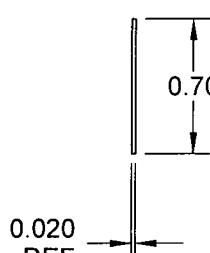
D3238-11 PLATE



D3238-13 PLATE



D3238-15 PLATE

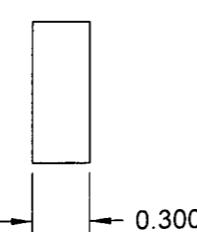
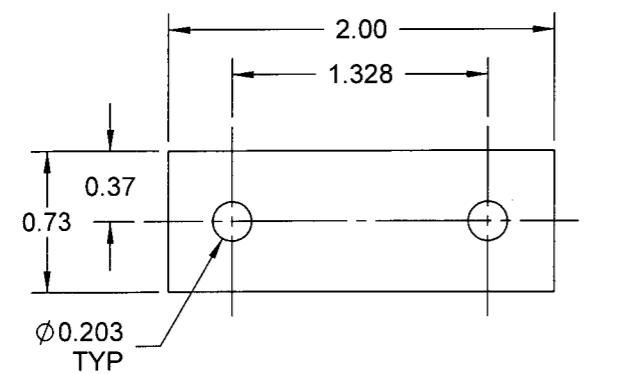
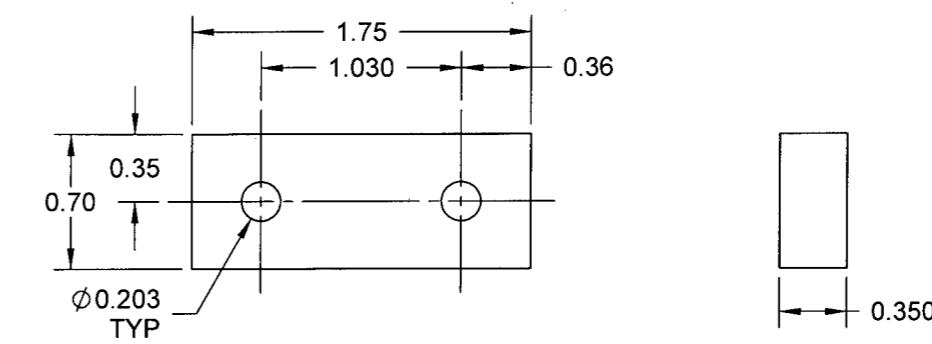
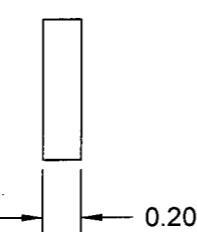
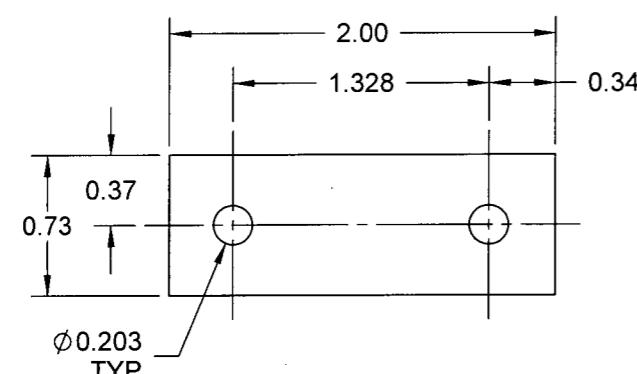
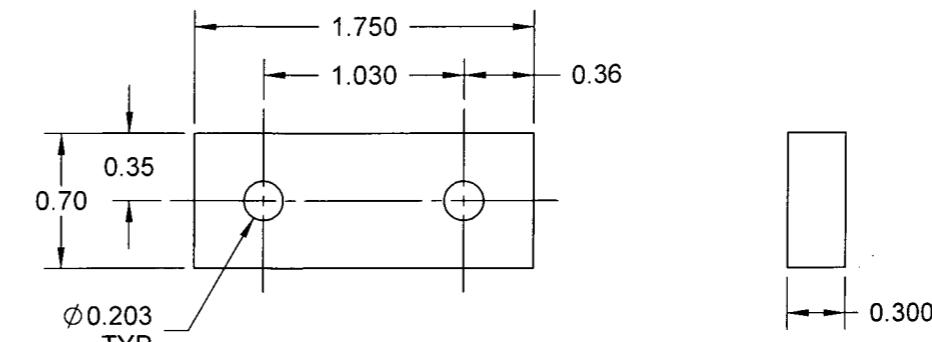
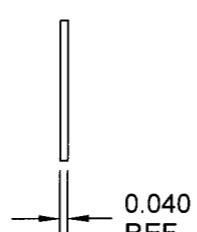
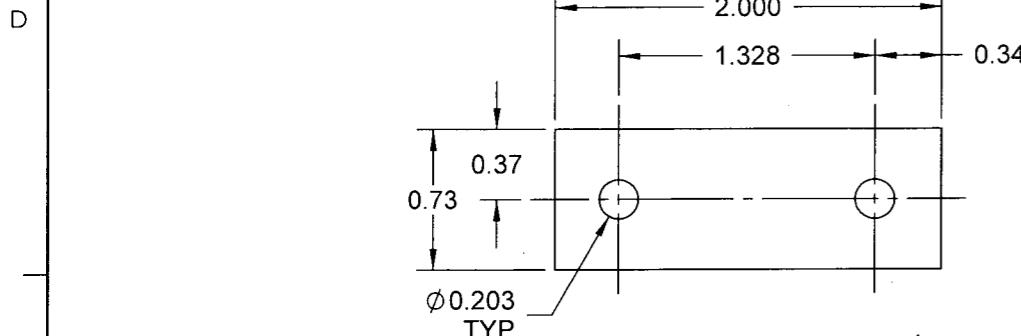


**DETAIL A
SCALE 4X**

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AJS 08.04.17

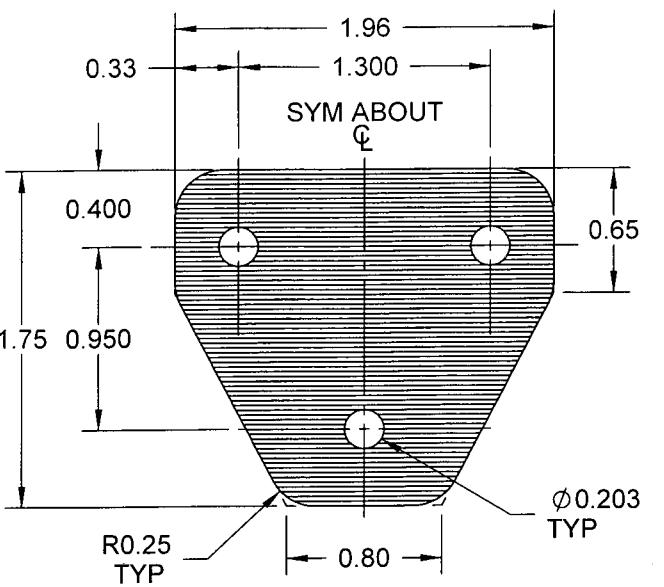
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DRAWN	AJS	
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MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.04.02	REV. D
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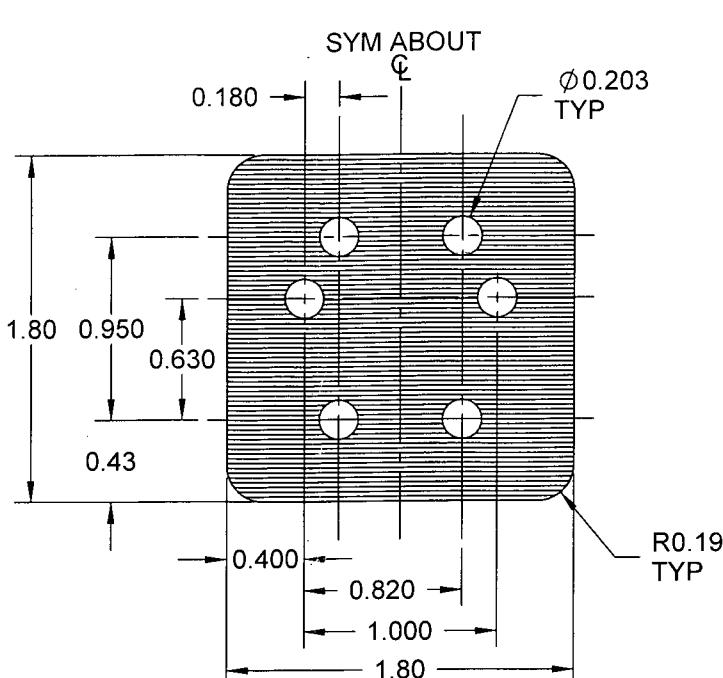


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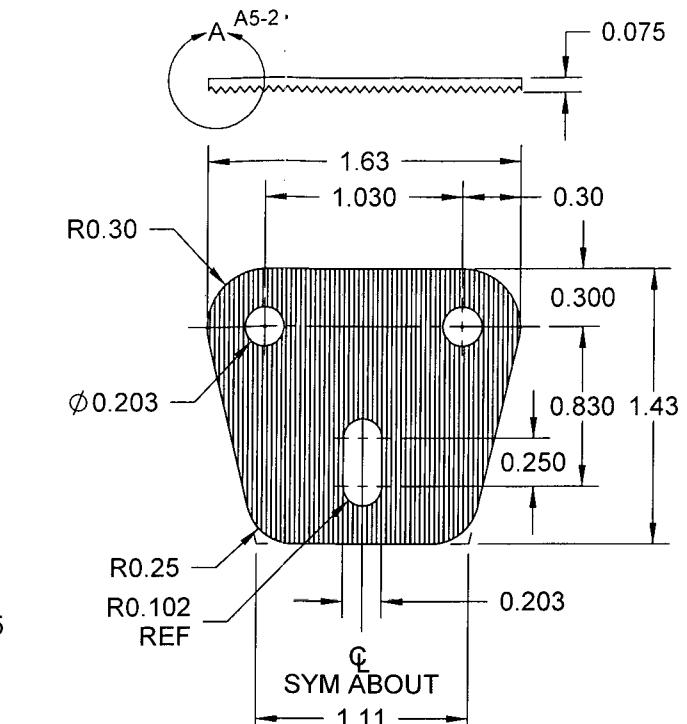
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D3238-21 PLATE

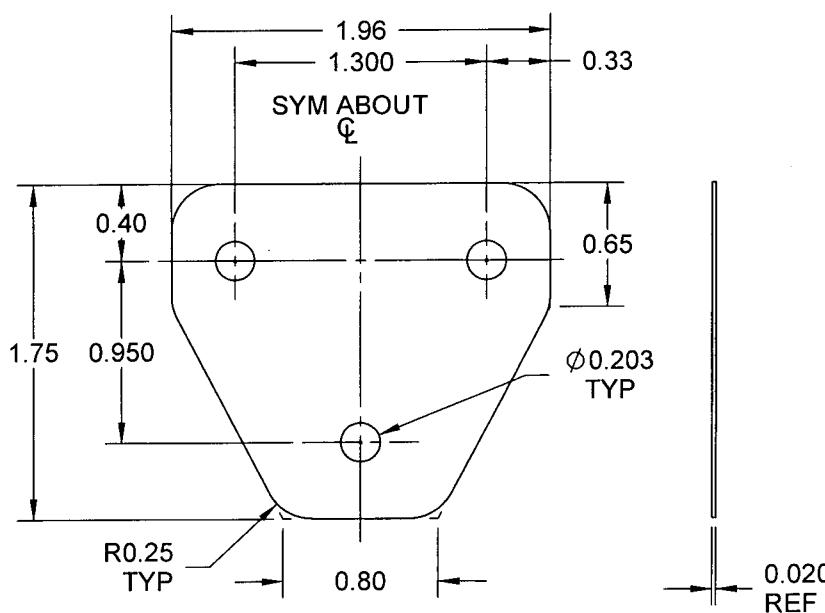


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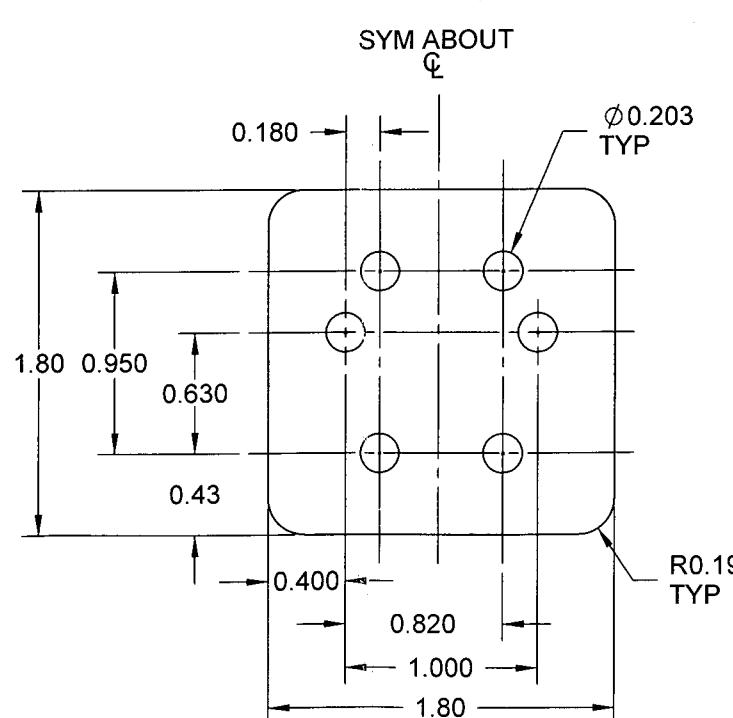


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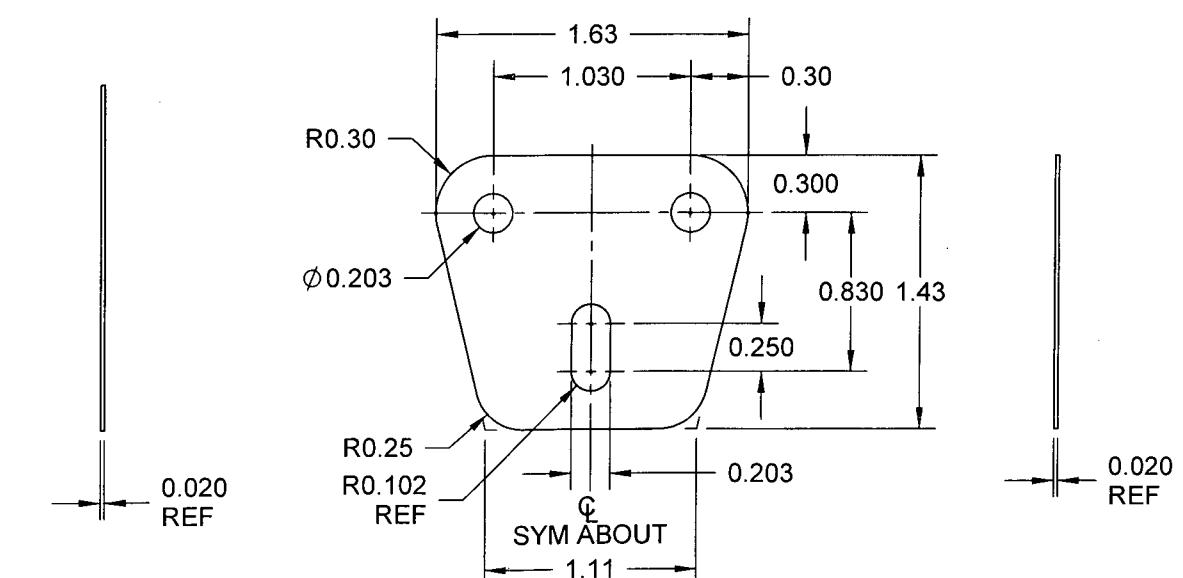
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D3238-31 PLATE



D3238-33 PLATE



D3238-35 PLATE

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO.
MFG. APPR.		D3238
APPROVED		REV. D
DE APPR.		SHEET 4 OF 4
DATE	08.04.02	SCALE
		NTS
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